

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025123**Date Inspected:** 08-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG 13 EAST

ZPMC NWIT: 09655

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13 East. The weld designations are as follows:

SEG3007J-012

SEG3007G-014

SEG3007M-040

This QA Inspector randomly observed the following work in progress.

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## WELDING INSPECTION REPORT

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OBG 13EAST

### FLUX CORED ARC WELDING PROCESS.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 055564 performing buttering on the edge plate (PL3213B) with the Flux Cored Arc Welding process. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-ESAB-Repair. Weld repair report identified as B-WR21211.

### SHIELDED METAL ARC WELDING PROCESS

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037779 performing the Shielded Metal Arc Welding process on weld 431 located at PCMK SEG3007C. ZPMC QC Mr. Liu Hua Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069118 performing the Shielded Metal Arc Welding process on weld 724 located at PCMK SEG3007AJ. ZPMC QC Mr. Liu Hua Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 501946 performing the Shielded Metal Arc Welding process on weld 730 located at PCMK SEG3007C. ZPMC QC Mr. Liu Hua Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2112-Fcm-1.

### ULTRASONIC TESTING

OBG 13 EAST

ZPMC NWIT: 09657

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13 East. The weld designations are as follows:

SEG3007B-158

SEG3007P-001

FB3121-001-178

FB2108-001-071

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer